

shp July 29/07

Work Order ID 72539



Page 1

Thursday, July 28, 2011 1:26:00 PM

Item ID: D2525-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 7/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Handwritten signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2525

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn Blank as per Dwg D2525-2-Deburr

OK 11/7/28

20 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

OK 11/7/28

20 0

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Y.A 11/07/28

20 0

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Required Date: 7/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20 0 20 4/07/29

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 0 16-7-29

150

Identify as per dwg & Stock Location: 5016

0.00



Packaging

Memo

0.00

Packaging

20 0 17/29 20

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/29

11-07-29

Picklist Print

Thursday, July 28, 2011 1:25:57 PM

Page 1

Work Order ID: 72539

Parent Item: D2525-5

Parent Item Name: Spacer



Start Date: 7/28/2011

Required Date: 7/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C C02.08.22 Make in Cobra KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.750

Purchased

No

100

f

38.5830

0.0208

0.437895



6061-T6 Round Bar .750"



1157128

Location

Loc Qty

Loc Code

MAT013

38.583

112442

0.796

116406

0.617

1117481

13.17

118106

24

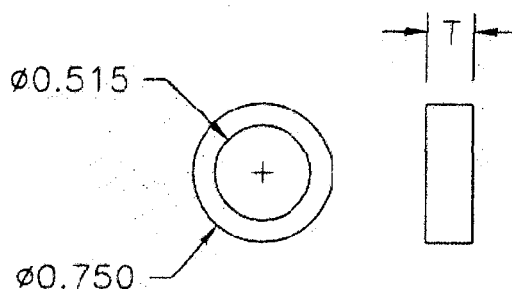
41



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2525	REV. B SHEET 1 OF 1
DATE 99.09.30		TITLE SPACER KIT	SCALE 1:1
A	95.12.22	NEW ISSUE	
B	99.09.30	REVISED MATERIAL	

RELEASED
99.10.12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

